

Date: Tuesday, 12/05/2009 8:59:11 AM  
 User: Julie Dawson

## Process Sheet

|  |   |
|--|---|
| <b>Customer</b> : CU-DAR001 Dart Helicopters Services  | <b>Drawing Name</b> : TURNING DETAIL FOR D2940-1            |
| <b>Job Number</b> : 47902  |   |
| <b>Estimate Number</b> : 13237   |   |
| <b>P.O. Number</b> :   | <b>Part Number</b> : DSK081                                 |
| <b>This Issue</b> : 12/05/2009 <b>S.O. No.</b> :   | <b>Drawing Number</b> : DSK081 REV.B                        |
| <b>Prsht Rev.</b> : NC   | <b>Project Number</b> : N/A                                 |
| <b>First Issue</b> : / / <b>Type</b> : MACHINED PARTS  | <b>Drawing Revision</b> : B                                 |
| <b>Previous Run</b> : 47786  | <b>Material</b> :   |
| <b>Written By</b> :  | <b>Due Date</b> : 22/05/2009 <b>Qty:</b> 10 <b>Um:</b> Each |
| <b>Checked &amp; Approved By</b> : <u>JLD 09.05.12</u>   |   |
| <b>Comment</b> : est rev A. 08.03.13 new issue EC<br>Est Rev:B 09-04-09 Now on Doosan Lathe JLM Verified By:EC |   |

## Additional Product

Job Number:



|                |                              |                      |
|----------------|------------------------------|----------------------|
| <b>Seq. #:</b> | <b>Machine Or Operation:</b> | <b>Description :</b> |
|----------------|------------------------------|----------------------|

|     |          |                    |
|-----|----------|--------------------|
| 1.0 | D6104007 | Round Billet, 17-4 |
|-----|----------|--------------------|



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Billet

BATCH: B 47934JLD 09/06/07

(10)

|     |              |              |
|-----|--------------|--------------|
| 2.0 | DOOSAN LATHE | DOOSAN LATHE |
|-----|--------------|--------------|

**Comment:** DOOSAN LATHE

Turn blank as per Folio FA079

JLD 09/06/08

(10)

|     |     |  |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINEJLD 09/06/08

(10)

|     |     |              |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|

**Comment:** SECOND CHECKmmf 09/06/11

|     |             |                       |
|-----|-------------|-----------------------|
| 5.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|

**Comment:** PACKAGING RESOURCE #1

Identify and Stock in Kanban

Location: \_\_\_\_\_

mmf 09/06/11

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Tuesday, 12/05/2009 8:59:11 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TURNING DETAIL FOR D2940-1

Job Number: 47902

Part Number: DSK081

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/11 JF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



NLF  
09-06-11

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

|  |               |                            |
|--|---------------|----------------------------|
| <b>DART AEROSPACE LTD</b>                      |               | <b>Work Order:</b> 47902   |
| <b>Description:</b> Turning Detail for D2940-1 |               | <b>Part Number:</b> DSK081 |
| <b>Inspection Dwg:</b> DSK081                  | <b>Rev:</b> B | <b>Page 1 of 1</b>         |

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

|               |       |       |                | Record Actual Dimensions |       |       |       |       |
|---------------|-------|-------|----------------|--------------------------|-------|-------|-------|-------|
| Dim           | Min   | Max   | Go/No Go Gauge | 1                        | 2     | 3     | 4     | 5     |
| Lathe Section |       |       |                |                          |       |       |       |       |
| A             | 3.211 | 3.216 |                | 3.212                    | 3.212 | 3.216 | 3.214 | 3.216 |
| B             | 4.946 | 4.966 |                | 4.957                    | 4.959 | 4.956 | 4.957 | 4.956 |
| C             | 0.718 | 0.738 |                | .724                     | .724  | .726  | .725  | .726  |
| D             | 0.090 | 0.110 |                | .102                     | .103  | .101  | .102  | .103  |
| E             | 3.564 | 3.584 |                | 3.576                    | 3.575 | 3.576 | 3.576 | 3.576 |
| F             | 0.022 | 0.042 |                | .032                     | .032  | .032  | .032  | .032  |
| G             | 3.444 | 3.464 |                | 3.454                    | 3.457 | 3.456 | 3.456 | 3.455 |
| H             | 0.112 | 0.132 |                | .120                     | .120  | .119  | .119  | .118  |
| I             | 2.170 | 2.190 |                | 2.175                    | 2.174 | 2.176 | 2.177 | 2.176 |
| J             | 4.451 | 4.471 |                | 4.461                    | 4.461 | 4.461 | 4.461 | 4.461 |
| K             | 0.413 | 0.433 |                | .425                     | .423  | .425  | .420  | .423  |
| L             | 0.913 | 0.933 |                | .923                     | .925  | .927  | .925  | .926  |
| M             |       |       |                |                          |       |       |       |       |
| N             |       |       |                |                          |       |       |       |       |
| O             |       |       |                |                          |       |       |       |       |
| P             |       |       |                |                          |       |       |       |       |

Measured by: *ml* Date: 09/06/08

Audited by: *mmf* Date: 09/06/11

Prototype Approval: Date:

| Rev | Date     | Change    | Revised by | Approved           |
|-----|----------|-----------|------------|--------------------|
| A   | 08.04.22 | New Issue | KJ/JLM     | <i>[Signature]</i> |

|  |               |                            |
|--|---------------|----------------------------|
| <b>DART AEROSPACE LTD</b>                      |               | <b>Work Order:</b> 47902   |
| <b>Description:</b> Turning Detail for D2940-1 |               | <b>Part Number:</b> DSK081 |
| <b>Inspection Dwg:</b> DSK081                  | <b>Rev:</b> B | <b>Page 1 of 1</b>         |

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article
 ☐ Prototype

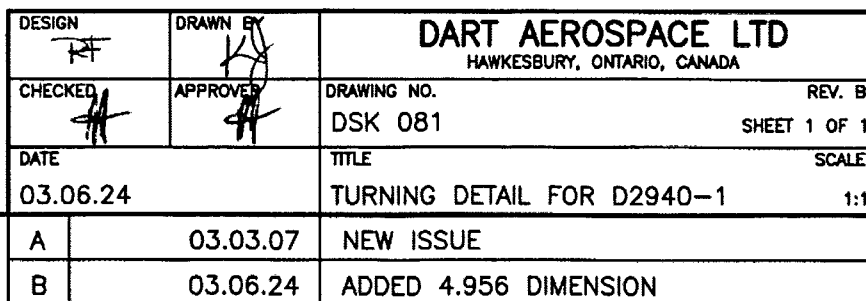
|               |       |       |                | Record Actual Dimensions |       |       |       |       |
|---------------|-------|-------|----------------|--------------------------|-------|-------|-------|-------|
| Dim           | Min   | Max   | Go/No Go Gauge | 1                        | 2     | 3     | 4     | 5     |
| Lathe Section |       |       |                |                          |       |       |       |       |
| A             | 3.211 | 3.216 |                | 3.213                    | 3.215 | 3.215 | 3.214 | 3.216 |
| B             | 4.946 | 4.966 |                | 4.954                    | 4.957 | 4.957 | 4.956 | 4.959 |
| C             | 0.718 | 0.738 |                | .724                     | .727  | .726  | .726  | .723  |
| D             | 0.090 | 0.110 |                | .101                     | .103  | .102  | .102  | .103  |
| E             | 3.564 | 3.584 |                | 3.575                    | 3.575 | 3.575 | 3.575 | 3.575 |
| F             | 0.022 | 0.042 |                | .032                     | .032  | .032  | .032  | .032  |
| G             | 3.444 | 3.464 |                | 3.455                    | 3.456 | 3.456 | 3.456 | 3.456 |
| H             | 0.112 | 0.132 |                | .121                     | .119  | .119  | .120  | .119  |
| I             | 2.170 | 2.190 |                | 2.178                    | 2.179 | 2.178 | 2.180 | 2.177 |
| J             | 4.451 | 4.471 |                | 4.461                    | 4.461 | 4.461 | 4.461 | 4.461 |
| K             | 0.413 | 0.433 |                | .422                     | .421  | .421  | .421  | .422  |
| L             | 0.913 | 0.933 |                | .923                     | .925  | .925  | .925  | .925  |
| M             |       |       |                |                          |       |       |       |       |
| N             |       |       |                |                          |       |       |       |       |
| O             |       |       |                |                          |       |       |       |       |
| P             |       |       |                |                          |       |       |       |       |

**Measured by:** *mx*
**Date:** 09/06/08

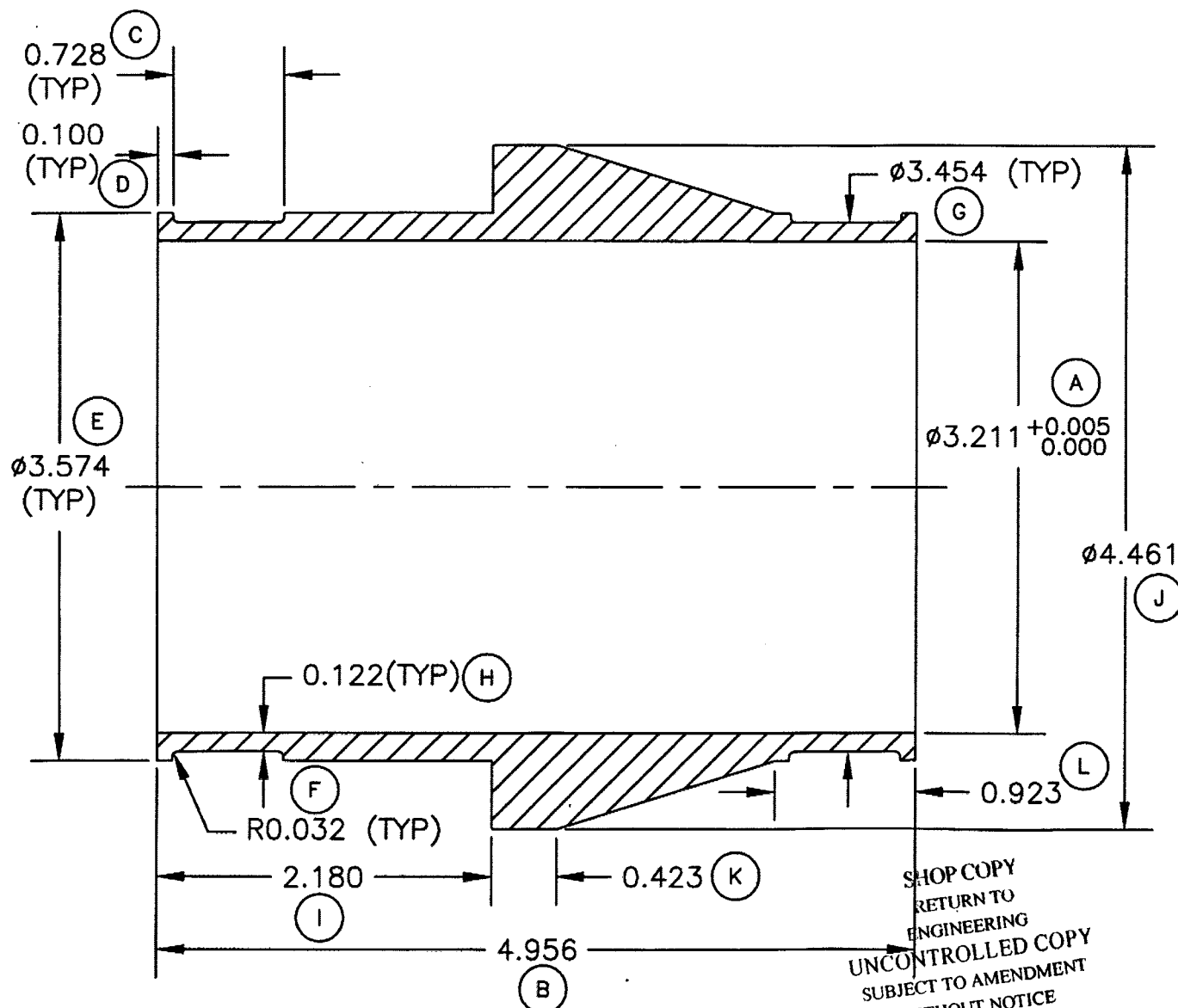
**Audited by:** *mte*
**Date:** 09/06/11

**Prototype Approval:**
**Date:**

| Rev | Date     | Change    | Revised by | Approved           |
|-----|----------|-----------|------------|--------------------|
| A   | 08.04.22 | New Issue | KJ/JLM     | <i>[Signature]</i> |



RELEASED  
03-07-01



D2940-1 TURNING DETAIL

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 57702

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